

# Work Order ID 73602

Wednesday, September 07, 2011 9:04:25 AM



Page 1

Item ID: D3436-5

Accept



Setup Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 9/7/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

QC:

Date:

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr
D3436	Rev A

100



Hardinge CNC LATHE SMALL

0.00

RR 11. 9. 8

10

Hardinge

Hardinge CNC Lathe Small

Memo

0.00

Turn as per Folio FA526 and Dwg D3436 , Deburr

110



QC2- Inspect parts off machine FAI/FAIB

0.00

RR 11. 7. 8

10

QC

Quality Control

120



QC8- Inspect parts - second check

0.00

on 11/09/08

10

QC

Quality Control

**Work Order ID 73602**

Wednesday, September 07, 2011 9:04:25 AM



Page 2

Item ID: D3436-5

Accept



Setup

Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 9/7/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



Packaging

Packaging

Operation  
DescriptionIdentify as per dwg & Stock Location: *W/A*Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

EZ 119-8

(X10)

Memo

0.00

\*\*\*\*\*STOCK IN LARGE FAB\*\*\*\*\*

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/9/8 JJ

MF 11-09-08

# Picklist Print

Wednesday, September 07, 2011 9:04:22 AM

Page 1

Work Order ID: 73602



Parent Item: D3436-5



Parent Item Name: Bushing

Start Date: 9/7/2011

Required Date: 9/8/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A 05.05.11 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.373W.049		Purchased	No			100	f	20.0000	0.1083	2.28			

4130 RD tube .373 x .049W



Location	Loc Qty	Loc Code
MAT032	20	
111329 ✓	20	1e133

RE 11-9-8

DART AEROSPACE LTD	Work Order:	J3602
Description: Bushing	Part Number:	D3436-5
Inspection Dwg: D3436 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

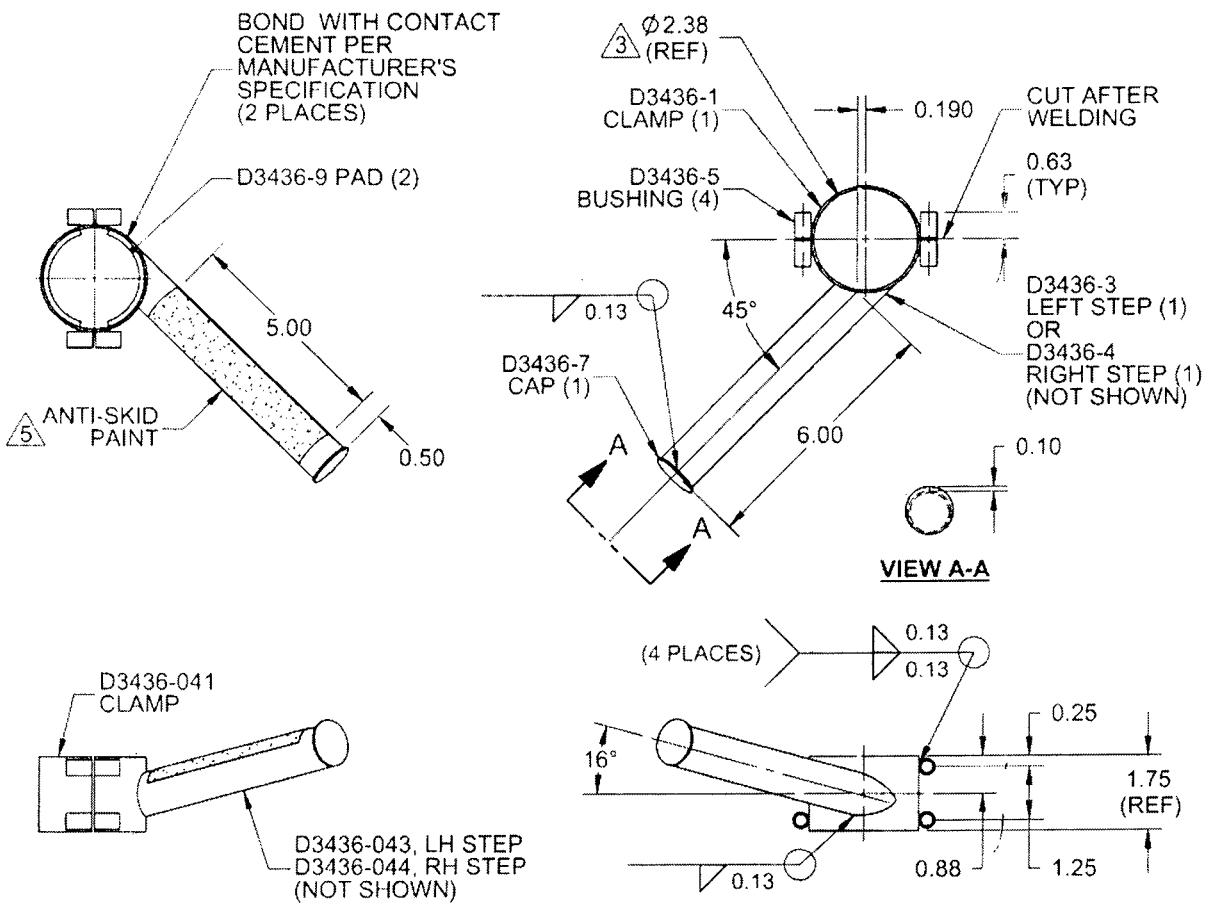
## X First Article      Prototype

Measured by:	RQ	Audited by:	mk	Prototype Approval:	N/A
Date:	11-9-8	Date:	11/09/88	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	05.07.07	New Issue	KJ/JLM	<i>[Signature]</i>



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:4
A	05.04.28	NEW ISSUE	



NOTES:

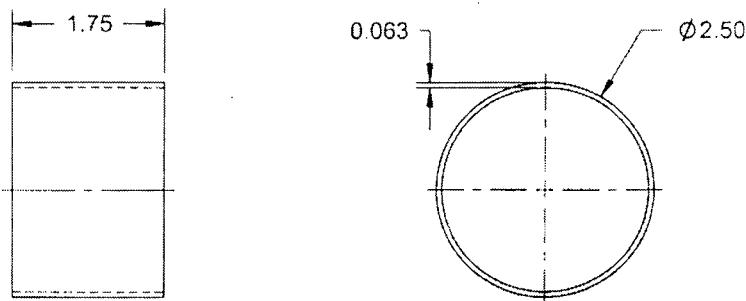
- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

RECALL NO:  
05-05 27-11

WV 3/6/02



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3436	REV. A	SHEET 2 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP	SCALE 1:2		



### **D3436-1 CLAMP**

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



### **D3436-5 BUSHING**

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

RE DESIGN  
05-05-27 *[initials]*

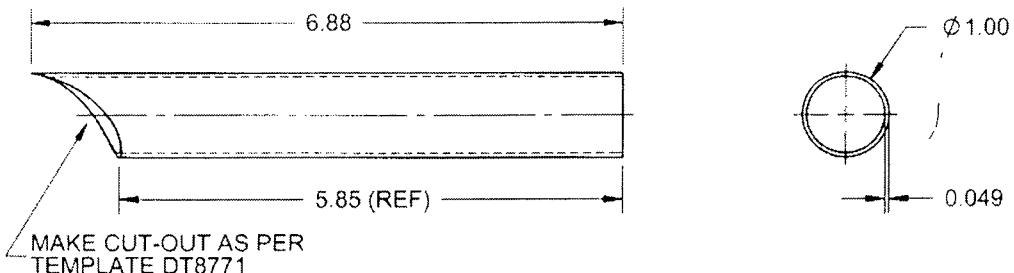
*X3602*

### **D3436-1/-5, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3436	REV. A	SHEET 3 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP	SCALE 1:2		

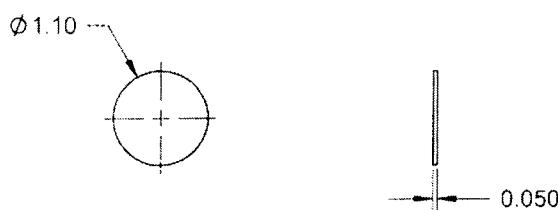


MAKE CUT-OUT AS PER  
TEMPLATE DT8771

### **D3436-3 LEFT STEP**

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



### **D3436-7 CAP**

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

### **D3436-3/-7, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

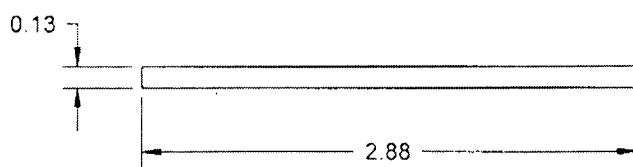
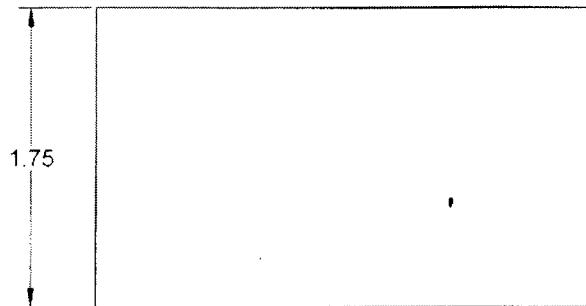
05-05-27  
X3602

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DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ff</i>	APPROVED <i>ff</i>	DRAWING NO. D3436	REV. A SHEET 4 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:1



DP  
05-05-27 *ff*

### D3436-9 PAD

#### NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK  
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

*X3602*

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